



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

5088581

D3457-1

Job Sheet 177187



Part No: D3457-1

Job Qty: 40 ea

Part Name: Washer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/20/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 05.10.03 New issue KJ/JLM IPP Rev:B Now on Doosan Lathe 08-10-30 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	6/20/18	6/20/18	0.00	0.00	Start Up Machining-2		<i>18/06/29</i>
100	Doosan	40 pcs	6/20/18	6/20/18	0.06	3.00	Doosan		<i>18/06/29</i>
120	QC	40 pcs	6/20/18	6/20/18	0.00	0.00	QC8		<i>18/03/08</i>
130	Packaging	40 pcs	6/20/18	6/20/18	0.00	0.00	Packaging3-1		<i>JUL 05 2018</i>
140	QC21-SA	40 Ea	6/20/18	6/20/18	0.00	0.00	QC21		<i>JUL 05 2018</i>

Part Op Descriptions: 100 - Turn as per Folio FA589 Rev: _____ & Dwg D3457 Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRINR1.000	Delrin Round Bar 1" Color: Black	.8320 ft (.0208 ea)	90-Start up Operation	<i>5030561</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELRINR1.000	1	17	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Washer	1.575inches ± 0.010	<i>1.575</i> 1.585 1.565		
2	Washer	0.030inches ± 0.010	<i>0.030</i> 0.040 0.020		
3	Washer	0.030inches ± 0.010	<i>0.030</i> 0.040 0.020		
4	Washer	0.530inches ± 0.010	<i>0.530</i> 0.540 0.520		
5	Washer	0.063inches ± 0.010	<i>0.063</i> 0.073 0.053		
6	Washer	0.169inches ± 0.010	<i>0.169</i> 0.179 0.159		
7	Washer	0.655inches ± 0.010	<i>0.655</i> 0.665 0.645		

QC / QA Coordinator Approval

FAULT CATEGORY

Positioned Wrong	
Outside Dimensions	
Over/Under tolerance	
Part Incorrect	
Part Lost/Missing	
Part Moved	
Drawing	
Finish	
Misread	
Turning Sequence	

Power Loss/Surge	
Folio/Program	
Grain	
Weld	
Wrong Stock Pulled	
Out of Sequence	
Off-set	
Mislabeled	
Fit/Function	
Misaligned/off center	

Temperature/Cure	
Set-up	
BOM/Route	
Broken/Damage/Defect	
Inspection Incomplete/Unqualified	
Contamination	
Countersink	
Cut Too Short	
Instructions Incomplete/Unclear	
Drill Holes	

Pressure/Forced	
Bending	
Centre Not Concentric	
Cracks	
Crimp/Kink/Ripple/Wave	
Cuffs	
Crushing	
Heat Treat	
Wave/Twist in Tube	
Marks/Chatter	

Root Cause

Environment	No Re-verification	
Design	Operator	
Doc/Data	Offset/Setup	
Equip/Tooling	Supplier	
Handling/Pre	Training	
Material	Use for Testing	
Internal Transport	Poor Information	
Tribal Knowledge	Rushing	
LOA	Product Improvement	
Substation	Process Improvement	
Past Expiry Date	Manufacturing Process	
Misidentified	Past Due	

OTHER :